



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-023

Job Sheet 172661



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 2/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials



Container No: S049164



Part: D3391 - 023

Job No: 172661

Serial No/Batch: S049164

Revision: J

Inspector:

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Date: 03/08/18

661750

5049164x1

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/22/18	0.00	0.00	Start Up Skid tubes-1		M661
100	Skid tubes	1 pcs		2/22/18	0.88	2.11	Skid tubes-4		M661 DAS
110	QC	1 pcs		2/22/18	0.00	0.00	QC5		38
120	HandFinish	1 pcs		2/22/18	0.00	0.38	HandFinish1		SA 18-3-12
130	QC	1 pcs		2/22/18	0.00	0.00	QC7-2		BE
140	Skid tubes	1 pcs		2/22/18	0.00	2.11	Skid tubes-4		M661, 38
150	QC	1 pcs		2/22/18	0.00	0.00	QC5		38
160	Skid tubes	1 pcs		2/22/18	0.00	2.11	Skid tubes-4		DAS
170	QC	1 pcs		2/22/18	0.00	0.00	QC10		DAS 38
180	QC	1 pcs		2/22/18	0.00	0.00	QC5		38 9-89
185	HandFinish	1 pcs		2/22/18	0.00	0.38	HandFinish2		SA 89-18-3-15
191	Spray Paint	1 pcs		2/22/18	0.00	0.91	Spray Paint		
192	Outsource	1 pcs		2/22/18			ATE003-VC		18-3-16
193	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging2		mat. 18/03/16
200	QC	1 pcs		2/22/18	0.00	0.00	QC14		BEB 18-03-19
230	HandFinish	1 pcs		2/23/18	0.00	0.38	HandFinish4		BEB DAS 03-19
240	QC	1 pcs		2/23/18	0.00	0.00	QC5		DAS 38
250	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1		21 9-89 SMB
260	QC21-SA	1 Ea		2/23/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
 Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
 holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of
 skid tube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 0.00" (see view F-
 E) 8- Transfer drill one fwd saddle hole only to .188" dia. transfer drill all remaining fwd saddle holes using DT 8149
 locating from previously drill .188" dia hole, using t-pins and elicos to ensure perfect alignment, open up previously transfer
 drilled pilot holes in D3391-023/024 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
 BATCH: 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
 DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
 section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to
 Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe
 140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in
 place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: batch#: NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE
 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush
 185 - Re-alodine
 191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: PAINT AS PER DWG AND
 QSI005 4.2.2.4 PAINT:
 230 - 1-Install Inserts as per Dwg

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skid tube Extrusion	1 Ea (1 ea)	90-Start up Operation	
D3389-1	Web	1 Ea (4 ea)	140-Skid tubes	5018458
D3681-1	Spacer	5 Ea (5 ea)	160-Skid tubes	5019147
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100 13163353	1	68	0
140-Skid tubes	D3389-1	1	9	0
160-Skid tubes	D3681-1	5	369	0
230-HandFinish	ALS4-1032-130 5007279	20	8,146	0
	D3591-1 5026944	2	75	0

Part Specifications	
Specifications could not be found.	

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

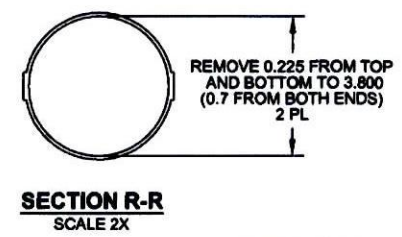
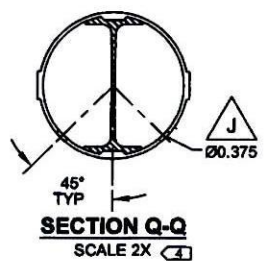
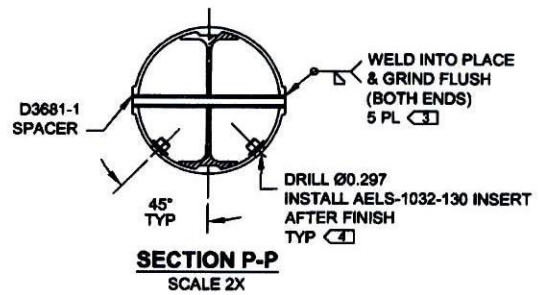
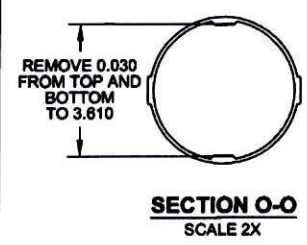
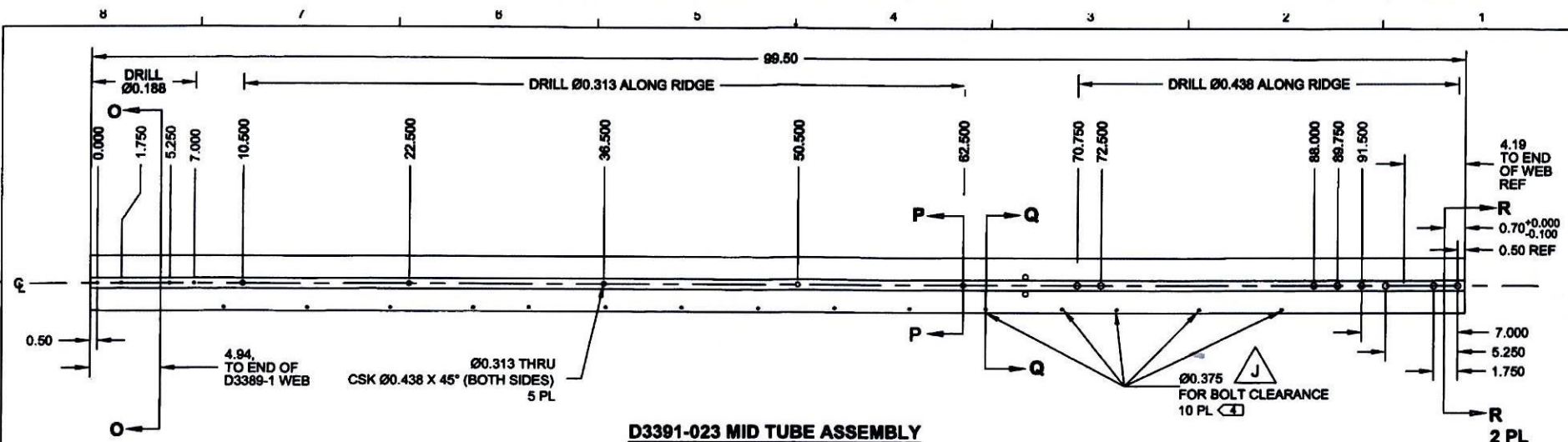
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C8A	BOLT
10	10	AN3C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27038C4-12	SCREW
4		NAS1149C0432R	WASHER



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NO. 172661
FEB 21 2018

J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-04-28
ECN 16-96



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004
 - 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	

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